

Date: Tuesday, 15/07/2008 9:16:20 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	DART 13-MAN 3-POINT SHOULDER HARNESS KIT	
<b>Job Number</b> :	40497			
<b>Estimate Number</b> :	12865			
<b>P.O. Number</b> :		<b>Part Number</b> :	D412702041B	
<b>This Issue</b> :	15/07/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	IIN D412-702 REV E	
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :	40226	<b>Drawing Revision</b> :	E	
<b>Written By</b> :		<b>Material</b> :		
<b>Checked &amp; Approved By</b> :	JLD 08.15.08	<b>Due Date</b> :	30/07/2008	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Comment</b> :	est rev A 07.05.10 new issue EC est rev C 07.06.20 changed AN44 4A to AN444A EC Est Rev:D 07-07-06 As per Rev E JLM Est Rev:E 08-03-31 now at chg003 ECN1150 DD verified by:			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL JLD 08.7.21 S 08/07/21  
 Photocopy bluefile & type labels per PPP D412-702-041B CHG003

2.0	D412702059	Grommet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 GROMMET KIT  
 batch: 40187

3.0	D412702101B	Harness Assembly
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 HARNESS ASSEMBLY  
 batch: 40533

4.0	D412702103B	Harness Assembly
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 HARNESS ASSEMBLY  
 batch: 40534

5.0	D412702105B	Harness Assembly
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 HARNESS ASSEMBLY  
 batch: 40535

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/07/2008 9:16:21 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40497

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

D412702107B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 40536

7.0

D412702109B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 40537

8.0

D412702111B

Harness Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: 40538

9.0

D412702113B

Harness Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: 40539

10.0

D412702115B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32491

11.0

D412702117B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32492

12.0

D35421

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BRACKET

batch: 38296

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/07/2008 9:16:21 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40497

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0

D35711

Guide



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

GUIDE

batch: 40222

14.0

D35713

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUIDE

batch: B31869

15.0

D3572041

Guide Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUIDE ASSEMBLY

batch: 31870

16.0

D3578041

Doubler



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

DOUBLER

batch: B39374

17.0

D3610041

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BRACKET

batch: 38301

18.0

D36181

CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CAP

batch: 32426

19.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: M105442

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 15/07/2008 9:16:21 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40497

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN416A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bolt  
batch: M19278

21.0	AN425A	BOLT
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
BOLT  
batch: M104438

22.0	AN444A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
bolt  
batch: M104806

23.0	MS24693S274	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw  
batch: M104014 1P M108560 1P

24.0	MS24694S56	SCREW
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
SCREW  
batch: M104407

25.0	MS24694S58	Screw
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
Screw  
batch: M104407

26.0	MS24694S60	Screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Screw  
batch: M104407

PC 8/1/17 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Tuesday, 15/07/2008 9:16:21 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40497

Part Number: D412702041B

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	AN960JD416	Washer
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Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)  
Washer  
batch: M107939

28.0	AN960JD416L	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer  
batch: M108138

29.0	MS21042L4	Nut
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)  
Nut  
batch: M107478

30.0	CR321244 4-04 CZ	Cherry Rivet
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)  
Cherry Rivet  
batch: M108602

31.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

32.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D412-702-041B CHG003  
Location: C  
PPP Rev: C

33.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E

Date: 07.06.27

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E

Date: 07.06.27

QTY -059	QTY -069	Part Number	Description
X		D412-702-059	GROMMET KIT
	X	D412-702-069	GROMMET KIT
48		D3619-1	GROMMET
1		D3619-1T1	HOLE PUNCH
1		D3619-1T2	STRIKER BLOCK
1		D3619-1T3	PUNCH
1		D3619-1T4	DIE
	24	D3619-2	GROMMET
	1	D3619-2T1	HOLE PUNCH
	1	D3619-2T2	STRIKER BLOCK
	1	D3619-2T3	PUNCH
	1	D3619-2T4	DIE

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Revision: E  
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